

Work Order ID 75872


75872

Page 1

Friday, November 18, 2011 10:01:31 AM

Item ID: K10112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan:  Date: 11-18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10112	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP K10112 CHG003 FOR D206-642-111 CHG007 112 FOR D206-642-113 CHG002 114								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

12-01-06 (4)
 J. R. M. L. S. 12-1-4
12/01/14 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75872

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Friday, November 18, 2011 10:01:31 AM

Item ID: K10112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				<u>rw</u>	<u>12</u>	<u>01</u>	<u>06</u> (4)
120									
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K10112								
	PPP D206-642-111								
	PPP D206-642-113								
	Location: <u>P/C</u>								
	PPP rev: <u>F</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/1/98

12/1/10

MF
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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K10112

Required Date: 12/9/2011

Required Qty: 4.00

Comments: IPP : E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F
11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A *AN5-10A* Bolt		Purchased	No				Each	872.0000		16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		872							
				116704		11							
				118191		59							
				119547		802							
AN5-11A *AN5-11A* Bolt		Purchased	No				Each	1,599.000		16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		21							
				117313		2							
				118191		19							
				ST518		1578							
				119512		1578							
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	1,655.000	18	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st510		1655							
				119042		1655							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

W/H
x4 AN4-6A
AN4-6A
Bolt

Purchased No

110 Each 5,062.000 12 48

**

Location Loc Qty Loc Code

ST356 62

119127 62

ST516 5000

119017 5000

110 Each 489.0000

**

Location Loc Qty Loc Code

FP-B 49

112243 49

ST355 440

112243 340

119017 100

110 Each 511.0000

**

Location Loc Qty Loc Code

ST343 7

119127 7

st510 504

119036 504

110 Each 1.0000

**

Location Loc Qty Loc Code

FG125 1

74002 1

W/H
x4 AN4C5A
AN4C5A
BOLT

Purchased No

W/H
x4 AN6-44A
AN6-44A
Bolt

Purchased No

W/H
x4 D206-651-041
D206-651-041
206A/B GHW

Manufactured No

119017

4

112243

8

119036

4

75450 10 12/10/15 (4)

26580 30

Friday, November 18, 2011 10:01:37 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

WJ
x4

D2652

Manufactured No

110

Each

743.0000

1 16 64

**

76132

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

WJ
x4

D2661-2

Manufactured No

110

Each

11.0000

1 2 8

**

76803 yx 12/10/11

76762

D2661-2

Saddle, RH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

6

10015

1

10016

1

10476

3

9913

1

ST435

5

74474

3

76517

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

WJ
x4
D2662-2
D2662-2
Saddle, RH In 206

Manufactured No

110 Each

29.0000

****** ² 8

76799 *Lu*

Location

Loc Qty

Loc Code

Mezz

2

11028

4

9042

3

9043

2

ST429

5

73852

2

76519

3

ST435

15

73853

15

Manufactured No

110 Each

2,551.000

****** ¹⁰ 40

76065 *Lu*

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

Manufactured No

110 Each

100.0000

****** ² 8

76065
76751 *Lu 12/15 (4)*

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

WJ
x4
D2884
D2884
Saddle Spacer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2885

Manufactured No

110

Each

126.0000

2 8

D2885

Saddle Spacer

**

76752

[Signature]

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

Manufactured No

110

Each

94.0000

1 4

D3413-1

D3413-1

Ring

**

[Signature]

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

73822

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

110

Each

8,753.000

8

32

**

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

11/90/17

MS21042L4

Purchased

No

110

Each

11,450.00

12

48

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

11/90/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L6 \

Purchased

No

110

Each

1,484.000

2

8

**

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

110

Each

1,379.000

1

4

**

NAS1149C0463R

Purchased

No

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8 32

**

119537

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24 96

**

1012/01/9 (4)

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:01:37 AM

Work Order ID: 75872

75872

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8

32

**

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

118206

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

**

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -113	QTY -114	QTY -151	QTY -149	PART NUMBER	DESCRIPTION
	X				D206-642-113	SKIDTUBE INSTALLATION, LH
		X			D206-642-114	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-151	SKIDTUBE
				X	D206-642-149	RUN-ON LANDING WEARPLATE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER ⁽²⁾
1			1		D3804-041	SKIDTUBE ASSEMBLY
2A			6		D2651-1	* PLUG ⁽¹⁾
2B			6		D2651-3	* O-RING ⁽¹⁾
3			1		D2646	* AFT CAP ⁽¹⁾
4			2		MS27039-1-08	* SCREW ⁽¹⁾
5			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1				D2661-1	SADDLE, FWD OUT, LH
6		1			D2661-2	SADDLE, FWD OUT, RH
7	1				D2662-1	SADDLE, FWD IN, LH
7		1			D2662-2	SADDLE, FWD IN, RH
8	1				D2661-1	SADDLE, AFT OUT, LH
8		1			D2661-2	SADDLE, AFT OUT, RH
9	1				D2662-1	SADDLE, AFT IN, LH
9		1			D2662-2	SADDLE, AFT IN, RH
10	8	8			AN3-41A	BOLT
11	16	16			D2652	BUSHING
12A	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4			AN5-7A	BOLT
14	4	4			AN5-7A	BOLT
15	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12			AN4-6A	BOLT
17	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12			MS21042-4	NUT (OR MS21042L4)
20A			1	1	D3805-041	FWD WEARPLATE ASSY
21A			1	1	D3807-1	* GASKET ⁽³⁾
22A			1	1	D3805-045	AFT WEARPLATE ASSY
23A			1	1	D3807-5	* GASKET ⁽⁴⁾
26A			7	7	AN3-36A	BOLT
26B			7	7	NAS1149D0363J	WASHER (OR AN960JD10)
26C			7	7	MS21042-3	NUT (OR MS21042L3)
26D			14	14	D3873-1	BUSHING
27				2	D2649	SPACER
28	2	2			AN6-44A	BOLT
29A	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1			AN4C5A	BOLT
35	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1			D3413-1	RING
37	10	10			D2712	SET SCREW
38	2	2			D2884	SPACER
39	2	2			D2885	SPACER

- NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3804-041 ASSEMBLY ABOVE
(2) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS
(3) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
(4) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	140	TITLE	SCALE
DE APPR.	140	BOLT SUBSTITUTION	NTS
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